

Date: Wednesday, 10/10/2007 11:04:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CABIN FLOOR PROTECTOR
Job Number	: 35090		
Estimate Number	: 12970		
P.O. Number	: <u>N/A</u>	Part Number	: D35746
This Issue	: 10/10/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3574 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: <u>N/A</u>	Material	: <u>N/A</u>
Written By	:	Due Date	: 11/2/2007
Checked & Approved By	: <u>[Signature] 071010</u>	Qty:	2 Um: Each
Comment	: Est Rev : A New Issue 07.07.23 EC verified by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029	lexan grey
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Comment: Qty.: 32.0000 sf(s)/Unit Total : 64.0000 sf(s)
 F60029 lexan sheet
 Batch: 103106 B07-10-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3574
 Dwg Rev: A
 Prog Rev: A

B07-10-17

(2)

2-Deburr if necessary

SAN 07/10/17

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/10/17

(2) counters

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAN 07/10/17

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/10/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35090

Part Number: D35746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/18

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/25 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)
07/10/25

Job Completion



U 07-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

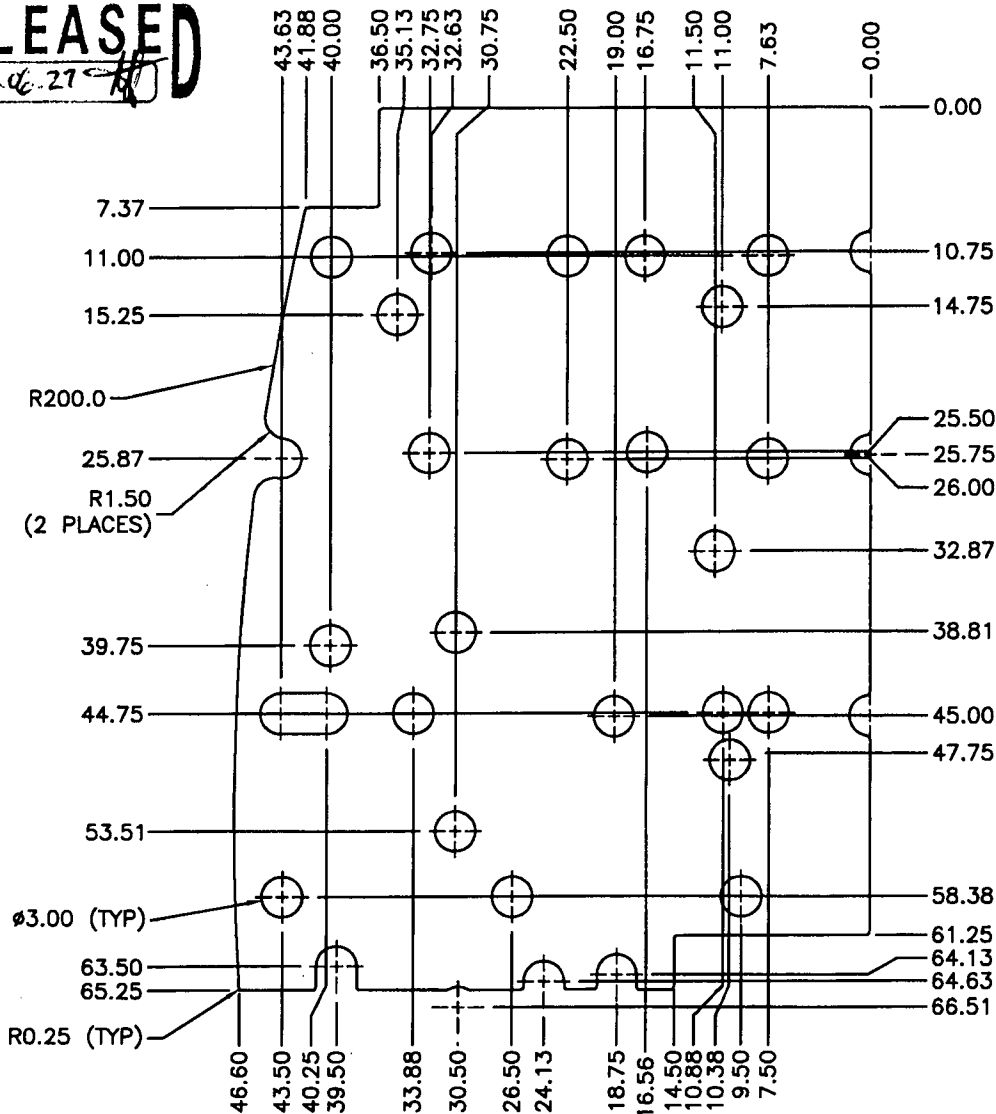
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, COPY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

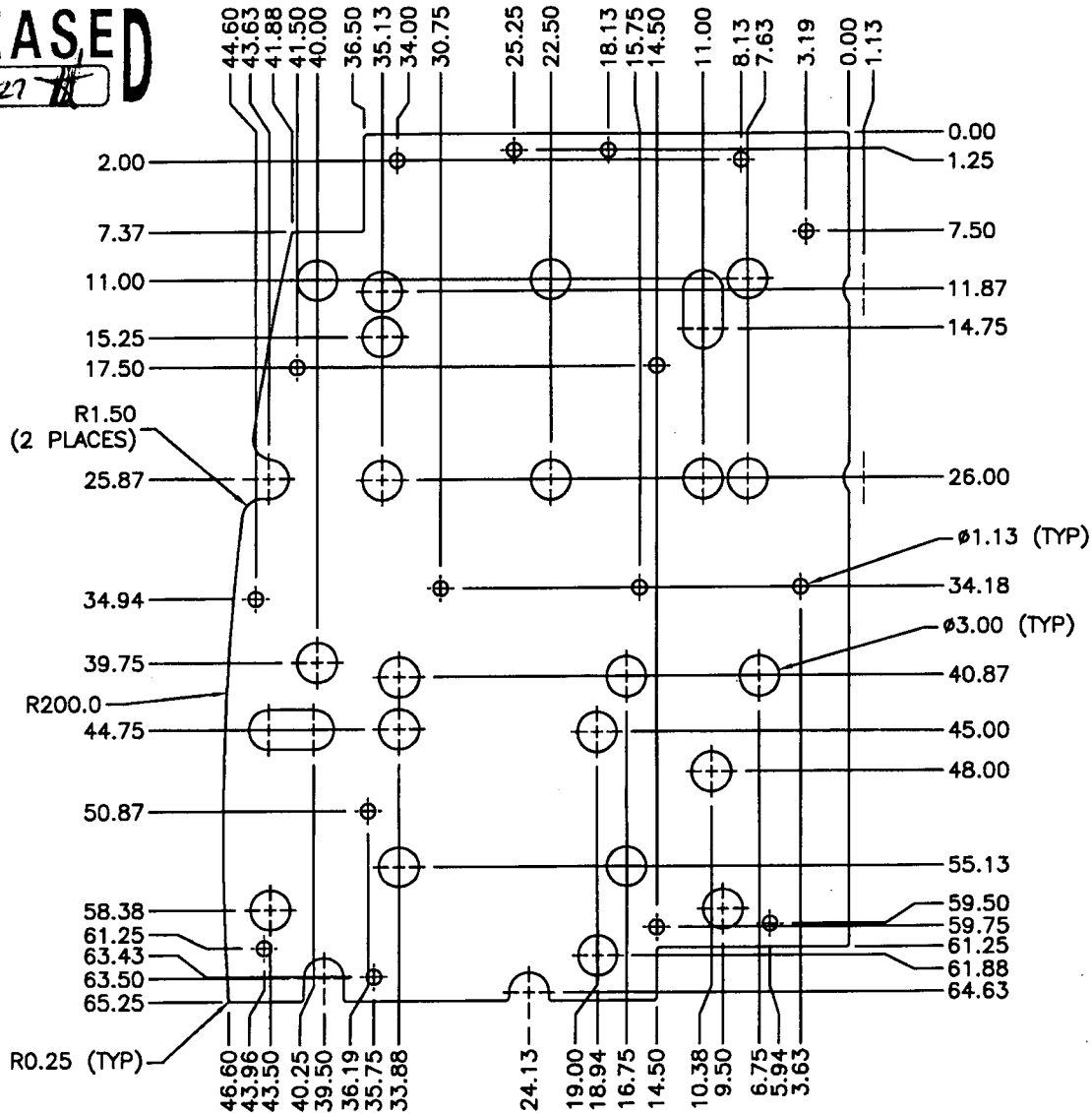
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27 *[Signature]***D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

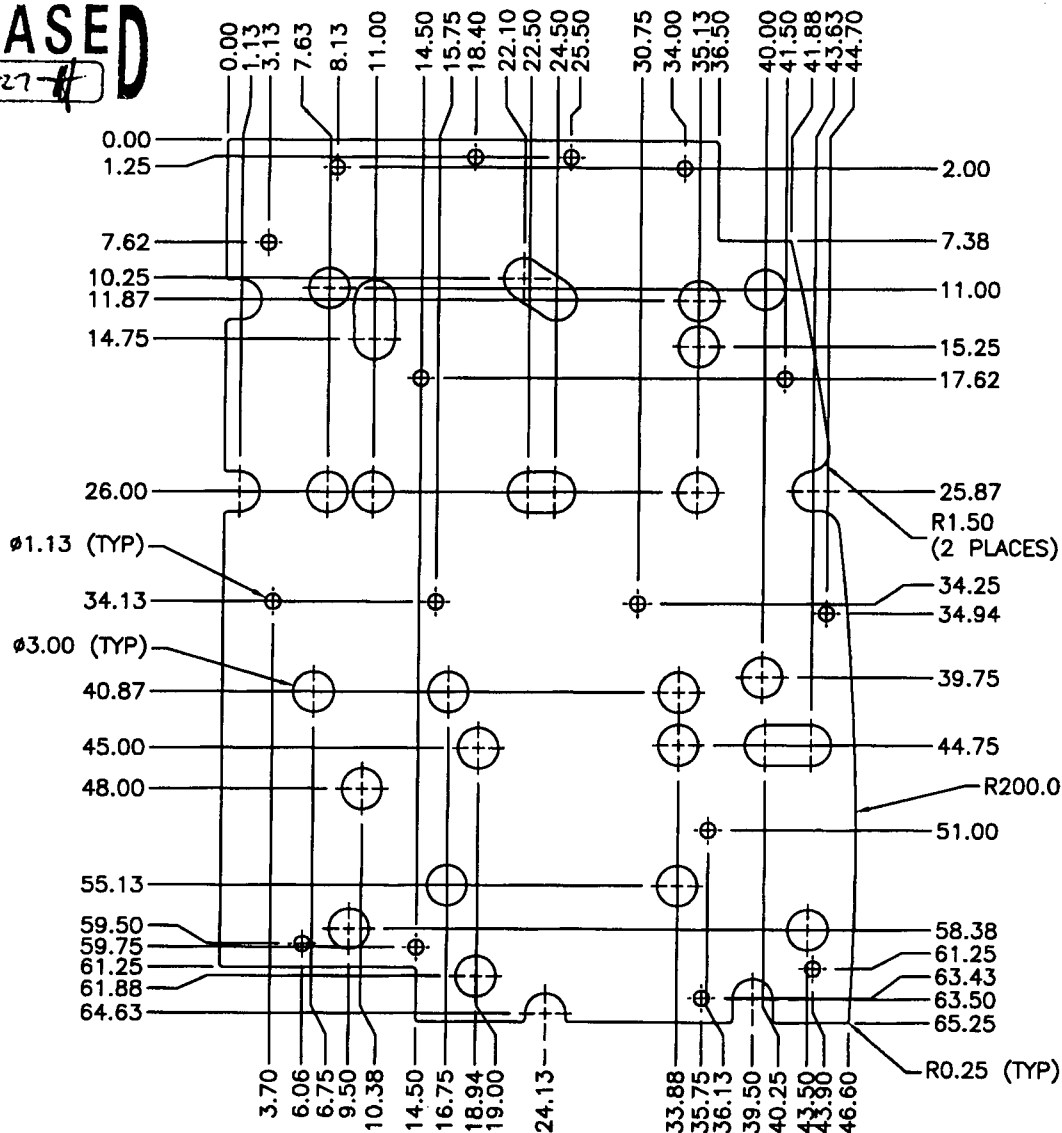
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27-#**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

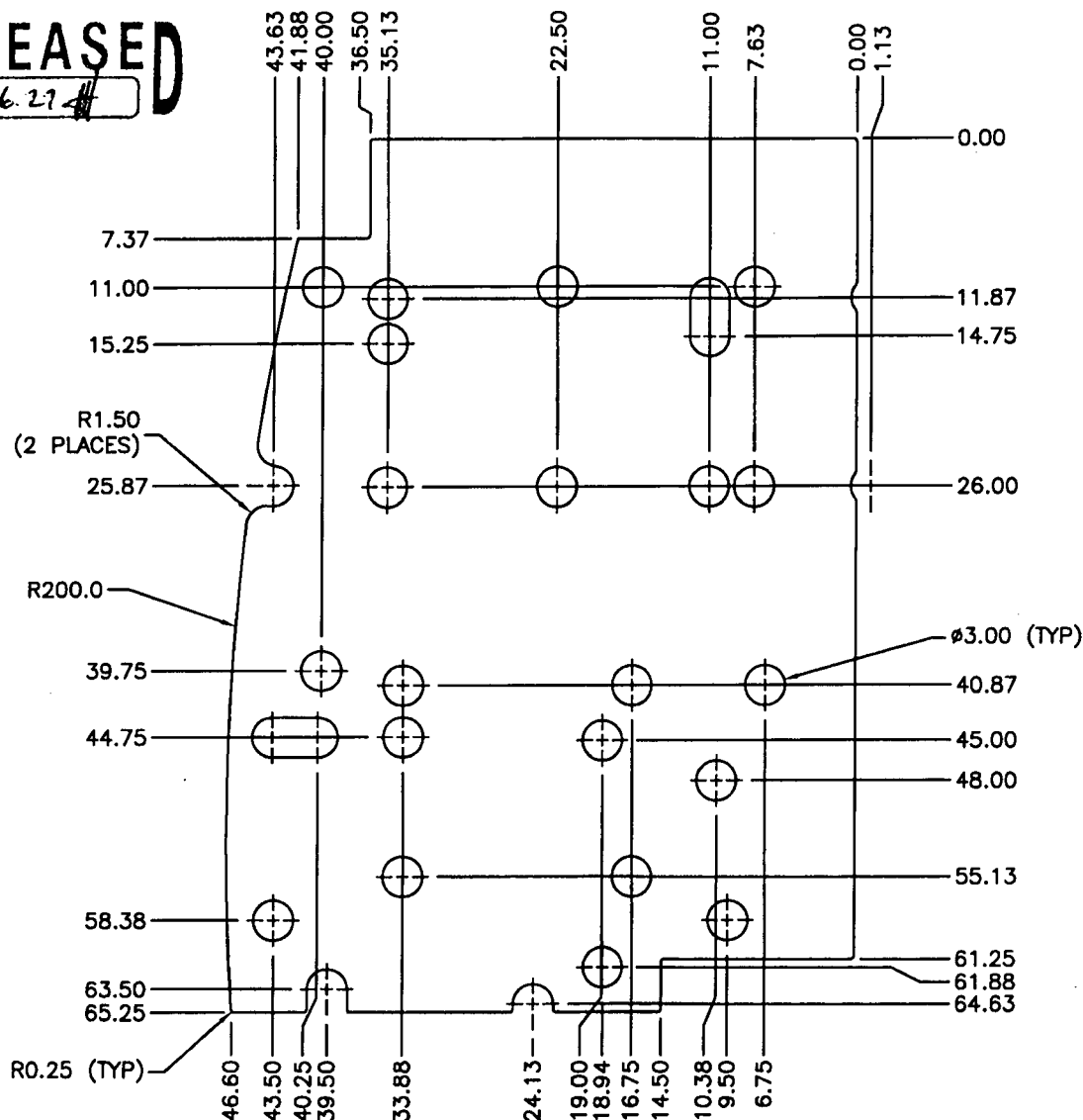
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

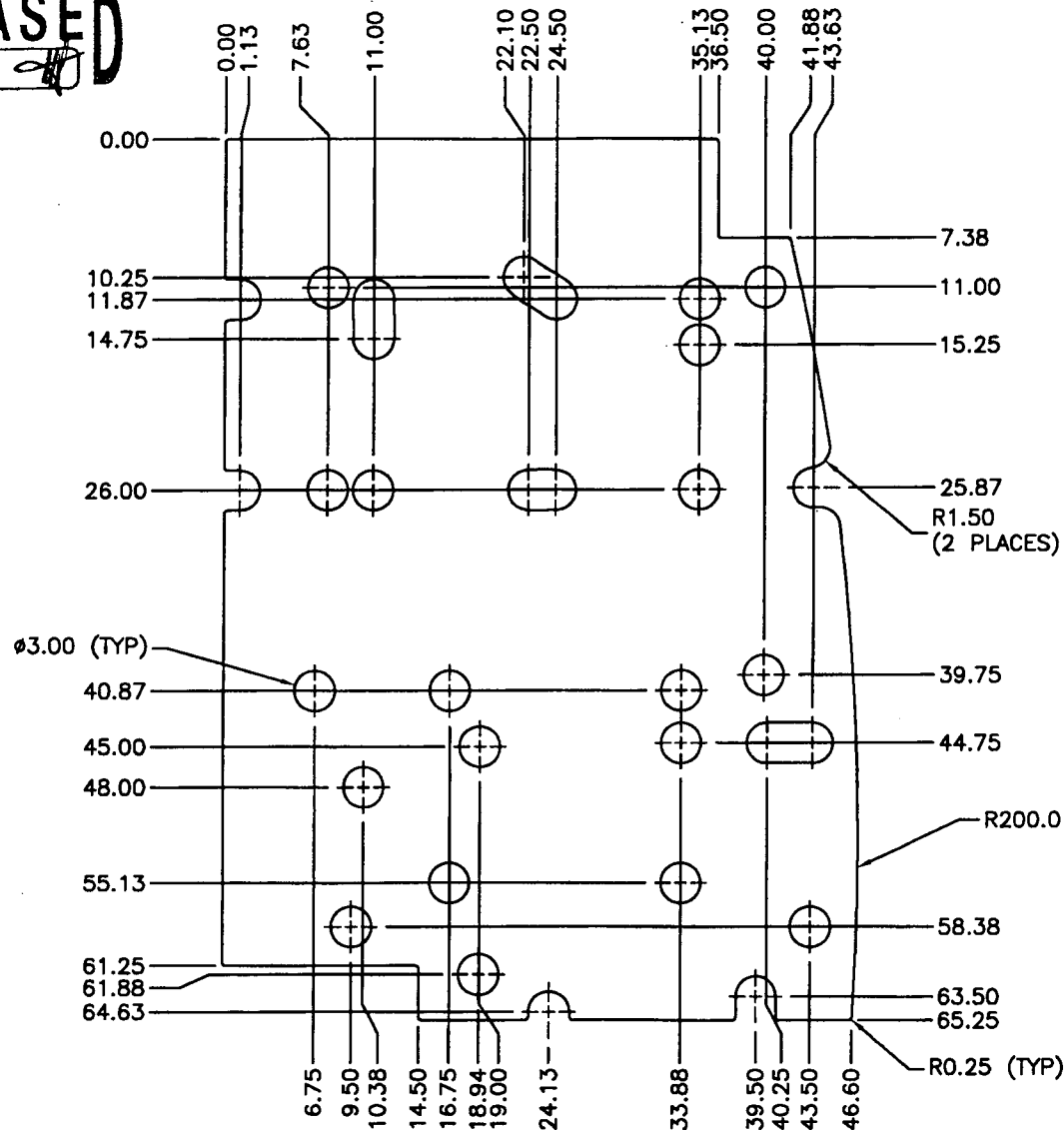
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CHECKED LE	APPROVED 	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order:	35090
Description: CABIN FLOOR PROTECTOR		Part Number:	3574-6
Inspection Dwg: D3574 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.13	+/- .030	1.13				
7.63	+/- .030	7.63				
11.00	+/- .030	11.00				
22.10	+/- .030	22.10				
22.50	+/- .030	22.50				
24.50	+/- .030	24.50				
35.13	+/- .030	35.13				
36.50	+/- .030	36.50				
40.00	+/- .030	40.00				
41.88	+/- .030	41.88				
43.63	+/- .030	43.63				
6.75	+/- .030	6.75				
9.50	+/- .030	9.50				
10.38	+/- .030	10.38				
14.50	+/- .030	14.50				
16.75	+/- .030	16.75				
18.94	+/- .030	18.94				
19.00	+/- .030	19.00				
24.13	+/- .030	24.13				
33.88	+/- .030	33.88				
39.50	+/- .030	39.50				
40.25	+/- .030	40.25				
43.50	+/- .030	43.50				
46.60	+/- .030	46.60				

Measured by:	HB
Date:	07-10-17

Audited by:	E
Date:	12/10/17

Prototype Approval:	n/a
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	35090
Description: CABIN FLOOR PROTECTOR		Part Number:	D3574-6
Inspection Dwg: D3574	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/- .030	10.25				
11.87	+/- .030	11.87				
14.75	+/- .030	14.75				
26.00	+/- .030	26.00				
40.87	+/- .030	40.87				
45.00	+/- .030	45.00				
48.00	+/- .030	48.00				
55.13	+/- .030	55.13				
61.25	+/- .030	61.25				
61.88	+/- .030	61.88				
64.63	+/- .030	64.63				
7.38	+/- .030	7.38				
11.00	+/- .030	11.00				
15.25	+/- .030	15.25				
25.87	+/- .030	25.87				
39.75	+/- .030	39.75				
44.75	+/- .030	44.75				
58.38	+/- .030	58.38				
63.50	+/- .030	63.50				
65.25	+/- .030	65.25				
Ø 3.00	+/- .030	2.91				

Measured by: HB	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: 07-10-17	Date: 07/10/17	Date: <i>[Signature]</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	